

Work Order ID 156207***156207***

Page 1

Friday, January 27, 2017 12:47:44 PM

Item ID: D2586 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Door Latch
Start Date: 1/19/2017 Start Qty: 25.00 ***25*** Cust Item ID:
Required Date: 1/27/2017 Req'd Qty: 25.00 ***25*** Customer:
Reference:

Approvals: Process Plan: **DAS 21 9-89** Date: **JAN 31 2017** Tooling: Date: Run Start ***NR1***
QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2586	Rev E								
100	PURCHASING	0.00				25	FEB 06 2017		DAS 13 9-89
100									
Purchasing	Memo	0.00							
Purchasing	Issue P/O: 35213								
	Possible Supplier: Southco, P/N: C2-32-25 TCH Sales								
	Certification Required								
110	Receive & Inspect for Damage & Mat'l Certs	0.00							
110									
Packaging	Memo	0.08							
Packaging	1-Attach certification								
	2-Keep Key with latch								
120	QC5- Inspect part completeness to step on W/O	0.00							
120									
QC	Memo	0.08				25			DAS 38 9-89
Quality Control									

FEB 13 2017

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY			
Environment ☐	☐ No Re-verification	Pressure/Forced ☐	☐ Temperature/Cure	☐ Power Loss/Surge	☐ Positioned Wrong		
Design ☐	☐ Operator	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐		
Doc/Data ☐	☐ Offset/Setup	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐		
Equip/Tooling ☐	☐ Supplier	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐		
Handling/Pre ☐	☐ Training	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐		
Material ☐	☐ Use for Testing	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐		
Internal Transport ☐	☐ Poor Information	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐		
Tribal Knowledge ☐	☐ Rushing	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐		
LOA ☐	☐ Product Improvement	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐		
Substation ☐	☐ Process Improvement	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐		
Past Expiry Date ☐	☐ Manufacturing Process	OTHER : _____					
Misidentified ☐	☐ Past Due						

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Page 2

NS1

Stop *NS2*

Customer:

Run Start *NR1*

Stop *NR2*

NR2

**Insp.
Stamp**

FEB 15 2017

1-Drill Hole to 0.191"
2-Counterface as per Dwg D2586
3-Assemble Lock Nut to Hinge. Leave Latch Unlocked.

PTO

24

0.08

Quality Control

DAS
38
9-99
FEB 16 2001

24

0.04

Packaging

Ensure key is bag with latch

DA
6
9-89

FEB 16 2017

DQA:

Date:

2017-04-05



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date:

MAR 09 2017

Work Order update only ☐

Work Order: <u>156207</u> Part No. <u>C23225</u> NCR No. <u>17-6323</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☒ Prod. Eng. Coord. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐					
Date: <u>FEB 15 2017</u>		Step #: <u>130</u>		QTY Effective: <u>1</u>			MRB (QSI042) Approval DAS 9-89 17-02-15 Completed By [Signature] Feb-15-17		
Description Work Order Deviation				Disposition				Lead hand / Supervisor Approval Verification DAS 30 9-89 FEB 15 2017 QC / QA Coordinator DAS 9-89 17-02-15 Approval	
Part C 23225 was not secured in vise on drill press, Therefore part got damaged operator did not secure vise to drill press				Scrap & destroy					
Root Cause Environment ☐ No Re-verification ☐ Design ☒ Operator ☐ Doc/Data ☐ Offset/Setup ☐ Equip/Tooling ☐ Supplier ☐ Handling/Pre ☐ Training ☐ Material ☐ Use for Testing ☐ Internal Transport ☐ Poor Information ☐ Tribal Knowledge ☐ Rushing ☐ LOA ☐ Product Improvement ☐ Substation ☐ Process Improvement ☐ Past Expiry Date ☐ Manufacturing Process ☐ Misidentified ☐ Past Due ☐		Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		FAULT CATEGORY Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ ☒ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
		OTHER: ☐							

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156207

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QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

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160	QC21 - Final Inspection - Work Order Release	0.00							
160									
QC	Memo	0.42					DAS 21 9-89	FEB 21 2017	
Quality Control									

MF
17-2-17

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Picklist Print

Friday, January 27, 2017 12:47:43 PM

Work Order ID: 156207

156207

Parent Item: D2586

D2586

Parent Item Name: Door Latch

Start Date: 1/19/2017

Required Date: 1/27/2017

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP E02.01.31 Added Inspect level 21NG IPP RevF: add not to keep key with latch DD 10.02.10 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
C23225		Purchased	No			110	Each	0.0000	1	25			
C23225									**				
DOOR LATCH													
D3015-7		Manufactured	No			130	Each	157.0000	1	25			
D3015-7									**				
Lock Nut													

Handwritten: 25x SP17-02-B
FF FEB 15 2017

Location

Loc Qty

Loc Code

ST015

157

144165

7

144974

150

25

DQA: _____ Date: _____

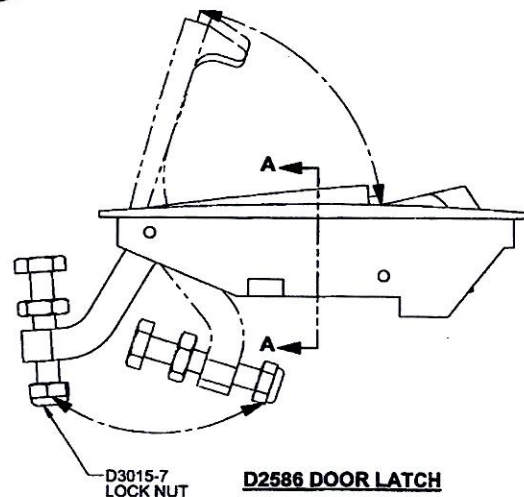
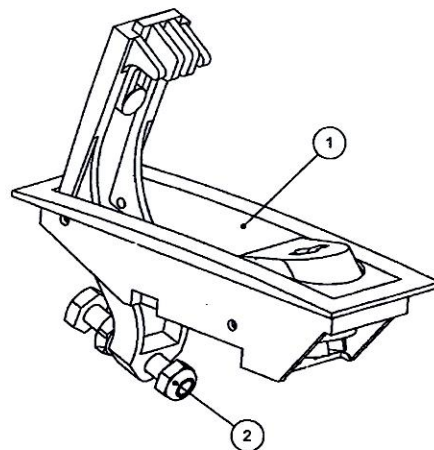


WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

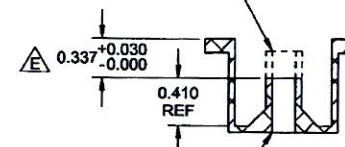
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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 156207 MJS
17-01-31

ITEM	QTY	P/N	DESCRIPTION
	X	D2586	LATCH ASSEMBLY
1	1	C2-32-25	LATCH
2	1	D3015-7	LOCK NUT

CBORE TOP TO
REMOVE MATERIAL FROM
EXISTING BOSS



DRILL OUT
EXISTING THREADS
TO Ø0.191

SECTION A-A

RELEASED
2011-07-04

NOTES:

- 1) MATERIAL: PURCHASE FROM SOUTHCO
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.15 lbs APPROX

E	REFORMAT, ZONE B3 UPDATED DIMENSIONS FOR CBORE. (SEE CAR 11-32)	AJS	11.06.13
D	ADD 3015-7 P/N; UPDATE DRAWING	CB	06.10.19
C	REVISED CBORE DEPTH	KE	97.09.03
B	CHANGED CBORE DEPTH	KE	97.07.23
A	NEW ISSUE	KE	96.07.15
REV.	DESCRIPTION	BY	DATE
DESIGN	KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. E
MFG. APPR.		D2586	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		DOOR LATCH	NTS
DATE	11.06.13	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO35213**

Purchase Order Date 2/6/2017 12:41:43 PM
PO Print Date 2/6/2017

Page Number 1 of 1

Order From :

VU-TCH001

Ship To : DART AEROSPACE LTD

T.C.H. SALES INC.
16757 BOUL. HYMUS

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

KIRKLAND, QUEBEC H9H 3L4

FEB 06 2017

Contact Name

Vendor Phone

514-697-7847

Ship To Contact

Ship To Phone

Ship Via:

FedEx Overnight collect

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

USD

FOB

Destination-Collect

Line Nbr	Reference Vendor Part Number	Description/ Mfg ID	Req Date/ Taxable	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
	Line Comments		Promise Date				
	Delivery Comments						
1	C23225	DOOR LATCH	2/10/2017 Yes 2/10/2017		25.00 Each	\$13.65	\$341.25
	AS PER DWG D2586 REV.E B156207						
						Line Total:	\$341.25
2	71401-45	PROCUREMENT QUALITY CLAUSES	2/10/2017 No 2/10/2017		1.00	\$0.00	\$0.00
	PROCUREMENT QUALITY CLAUSES A005 RIGHT OF ENTRY A016 PERSONNEL QUALIFICATION A025 CERTIFICATE OF CONFORMANCE A040 NOTIFICATION OF QUALITY ESCAPE A042 DART NOTIFICATION BY SUPPLIER A043 RETENTION OF QUALITY DOCUMENT					Line Total:	\$0.00

PO Total:

\$341.25

Note: Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Change Nbr: 1

Change Date: 2/6/2017

T.C.H. Sales Inc.
 40 Emblem Court
 Toronto, Ontario M1S 1B1
 Phone: 1-800-465-6281
 Fax : 1-855-299-3214



PACKING SLIP

VENDOR #	
DUNS #	242445328
TAX #	R105150197

CUSTOMER NUMERO DU CLIENT	STORE NUMBER NUMERO MARCHE	DEPARTMENT DIVISION	CUSTOMER PO COMMANDE DU CLIENT	ORDER COMMANDE	PACK NUMBER BON DE LIVRAISON	BOL NUMBER BOL NUMBER	PICK # NUMERO PICK	A/R TERMS A/R TERMES	PAGE PAGE
22428000			PO35213	170117	201164		223518	30	1

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 DART AEROSPACE LTD.
 1270 ABERDEEN
 HAWKESBURY ON K6A 1K7

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 DART AEROSPACE LTD.
 1270 ABERDEEN
 HAWKESBURY ON K6A 1K7
 CAN

TEL: 613-632-9577

SHIP TERM CODE DE TRANSIT	SHIP VIA TRANSITAIRE	TRACER NUMERO DE TRACER	PACK DATE DATE DE PACK	CANCEL DATE DATE DE CANCEL	PCS PCS	WEIGHT POIDS	MEMO MESSAGES DIVERS
COLL	FedEx Priority	7210 2352 6068	02/08/17	12/31/18	1	13	

PRODUCT CODE CODE DU PRODUIT	DESCRIPTION	ORDERED COMMANDEE	SHIPPED EXPIDIEE	BACK ORDERED NON EXPIDIEE
555-C23225	BLK LEV LATCH RAISED TRIG W/LK C2-32-25	25	25	0
SP# 02-13 DAS 38 3-89				
		25	25	0

Visit Us Online

www.tchweb.com

Conditions Of Sale:

All shipments FOB Scarborough, Ontario.
 All returns are subject to a 15% handling charge and must be authorized.
 All claims and discrepancies must be reported within 7 days.
 We have the right to charge collection and attorney's fees of 25% and
 interest of 2% per month (or 24% per annum) on all overdue accounts.

Conditions De Vente:

Tous les retours de marchandises sont soumis a des frais de manutention de 15% et a l'autorisation.
 Veuillez signaler toutes les anomalies ou irregularites dans les sept jours.
 Nous avons le droit d'imposer dans frais de recouvrement et de procedure de 25%, ainsi qu'un interet de 2%
 par mois (ou 24% par an) sur tous les comptes en souffrance.
 Les biens faisant l'objet de la presente facture demeurent la propriete du vendeur jusqu'a parfait paiement.